

Work Order ID 144715

April 22, 2016 12:36:49 PM

144715

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Item ID: D350-578-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: AS350/AS355 Bearpaws

Stop

NS2

Start Date: 4/22/2016 Start Qty: 8.00

8

Cust Item ID:

Required Date: 5/6/2016 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date:

0160421

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D350-578

H

100

Document Control

0.00

DAS

8

9-89

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D350-578-011 CHG006

8

DAS

28

9-89

MAY 09 2016

MW 1604-258

160

Pick Kit

0.00

160

Packaging

Memo

0.00

Packaging

8

DAS

8

9-89

DAS

27

9-89

APR 25 2016

170

QC4- 100% Inspect kits for completeness

0.00

170

QC

Memo

0.24

Quality Control

8

DAS

28

9-89

MAY 09 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

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Stop

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Start Date: 4/22/2016 Start Qty: 8.00

8

Cust Item ID:

Required Date: 5/6/2016 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Packaging	0.00							
180									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-578-011 Location: F6 013								
190	QC21 - Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.80							
Quality Control									

8 DAS 28 9-89 MAY 09 2016

MW MAY 10 2016
Lm 16/05/09

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
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Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

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144715

D350-578-011

Start Date: 4/22/2016**Required Date:** 5/6/2016**Start Qty: 8.00**

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-01-02 JLM
IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC
IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified
By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status BAS
D2432		Manufactured	No			160	Each	0.0000	2	16			DAS 27 6 9-89
D2432	DAS 28 9-89								**	144342			9-89
Bearpaw 19" X 24"													
D2529		Manufactured	No			160	Each	628.0000	12	96			DAS 27 6 9-89
D2529									**				DAS 27 6 9-89
Washer													9-89
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
	DAS 28 9-89			ST008			500			96			
				143819			500						
				ST009			128						
				141458			128						
D3601-1		Manufactured	No				Each	2.0000	12	96			DAS 27 6 9-89
D3601-1	DAS 28 9-89								**	1314330			DAS 27 6 9-89
Radius Block													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST046			2						
				141269			2						
D4011-1		Manufactured	No				Each	36.0000	6	48			DAS 27 6 9-89
D4011-1									**	12X13 145016			DAS 27 6 9-89
Clamp, Short													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
	DAS 28 9-89			ST544			36			36			
				141469			36						

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Picklist Print

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Work Order ID: 144715

144715

Parent Item: D350-578-011

D350-578-011

Parent Item Name: AS350/AS355 Bearpaws

Start Date: 4/22/2016

Required Date: 5/6/2016

Start Qty: 8.00

Required Qty: 8.00

D4012-1 Manufactured No

Each 26.0000

D4012-1

Cushion

**

48
27Xβ 144666

DAS
6
9-89
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

5

133458

5

ST545

21

143847

21

Each

210.0000

12 96

**

DAS
6
9-89
27
9-89

AN4-16A

Purchased No

AN4-16A

Bolt

Location

Loc Qty

Loc Code

FG

5

121541

5

over003

125

M134606

125

ST343

80

M134509

80

DAS
28
9-89

FB6Y
32

AF 20 2010

Picklist Print

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Work Order ID: 144715

144715

Parent Item: D350-578-011

D350-578-011

Parent Item Name: AS350/AS355 Bearpaws

Start Date: 4/22/2016

Required Date: 5/6/2016

Start Qty: 8.00

Required Qty: 8.00

NAS1149D0463J

Purchased

No

160

Each

2,824.000

24

192

NAS1149D0463.J

WASHER

DAS 27
9-89

Location

Loc Qty

Loc Code

GA

342

M132035

21

M134508

321

ST260a

600

M134508

600

ST263

894

M134039

29

M134573

865

192

ST269

988

M132317

100

M132677

888

DAS
28
9-89

MS21042L4

Purchased

No

160

Each

2,054.000

12

96

MS21042L 4

Locknut

DAS 27
9-89

Location

Loc Qty

Loc Code

GA

288

m133769

288

OVER007

1500

m134509

500

m134606

1000

95

ST303

169

m134055

1

m134502

168

1

ST305

97

m130922

97

DAS
28
9-89

APR 25 2016

REFERENCE ONLY

5.0 PARTS LIST

5.1 D350-578-011/-013/-015/-017/-021 BEARPAW INSTALLATION

Qty -011	Qty -013	Qty -015	Qty -017	Qty -021	Qty -031	Part Number	Description
X						D350-578-011	BEARPAW INSTALLATION
	X					D350-578-013	BEARPAW INSTALLATION
		X				D350-578-015	BEARPAW INSTALLATION
			X			D350-578-017	BEARPAW INSTALLATION
				X		D350-578-021	BEARPAW INSTALLATION
					X	D350-578-031	WEARPLATE KIT
2						D2432F	Bearpaw
		2				D2432-3	Bearpaw
12	12	12	12	12		D2529	Washer
				2		D2672F	Bearpaw
12	12	12	12	12		D3601-1	Radius Block (Replaces D2274)
					2	D3859-041	Wearplate
6	6	6	6	6		D4011-1	Clamp (Replaces D2438)
6	6	6	6	6		D4012-1	Cushion (Replaces D2182B050)
	2					D4297-1	Bearpaw
			2			D4297-3	Bearpaw
12	12			12	12	AN4-16A	Bolt
		12	12		12	AN4-17A	Bolt
24	24	24	24	24	24	NAS1149D0463J	Washer
12	12	12	12	12	12	MS21042L4	Nut (or MS21042-4)

5.2 D350-578-111/-113/-115/-117/-121 BEARPAW INSTALLATION

Qty -111	Qty -113	Qty -115	Qty -117	Qty -121	Part Number	Description
X					D350-578-111	BEARPAW INSTALLATION
	X				D350-578-113	BEARPAW INSTALLATION
		X			D350-578-115	BEARPAW INSTALLATION
			X		D350-578-117	BEARPAW INSTALLATION
				X	D350-578-121	BEARPAW INSTALLATION
1					D350-578-011	Bearpaw Installation
	1				D350-578-013	Bearpaw Installation
		1			D350-578-015	Bearpaw Installation
			1		D350-578-017	Bearpaw Installation
				1	D350-578-021	Bearpaw Installation
1	1	1	1	1	D350-578-031	Wearplate Kit